

Work Order ID 103087

103087

Page 1

June-12-13 9:26:45 AM

Item ID: D3885-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Standard Web

Start Date: 6/06/13 Start Qty: 8.00

8

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals:

Process Plan:

Date: 1306-11 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3885	B

100 0.00

100

Purchasing

Memo

0.00

Purchasing

Purchasing

Issue P/O: 20178

Supplier: WEJAY.

Machine as per Dwg D3885

Conformity sheet required

CD 13/06/11.4 (8)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

13/7/11.8 (8)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 103087

103087

Page 2

June-12-13 9:26:45 AM

Item ID: D3885-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Standard Web

Start Date: 6/06/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				7	1		
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

PTO

24/

13-7-20

DP 13-8-1

DQA:

Date: 13/08/22

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: <u>103087</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3885-3</u>		Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. _____		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input checked="" type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	13.7.18	#120	1	part damaged due to cutter leakage non conforming Supplier	DAS 16 9-8 05/07/18	part scrap and destroyed no Replace	DAS 16 9-8 13.7.18		DAS 16 9-8 05/07/18
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport						contact supplier of issue + have a Root cause Email Attached	\$ 581.98		13/07/18
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 103087

103087

Page 3

June-12-13 9:26:45 AM

Item ID: D3885-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Standard Web

Start Date: 6/06/13 Start Qty: 8.00 *8*

Cust Item ID:

Required Date: 6/11/13 Req'd Qty: 8.00 *8*

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: 46	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13-8-1
⑦

MCS 13-08-09
MCF
13-8-09

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

June-12-13 9:26:45 AM

Page 1

Work Order ID: 103087
 Parent Item: D3885-3
 Parent Item Name: Standard Web

Start Date: 6/06/13 Required Date: 6/11/13
 Start Qty: 8.00 Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3882-1-130 Extrusion "I" Beam		Manufactured	No			110	Each	59.0000	1	8		6/13/06/18	
				<u>Location</u>		<u>Loc Qty</u>							
				LG		59							
				93832		59							
D3885-3P Standard Web		Purchased	No				Each	0.0000		8		6/3/17/18 (8)	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

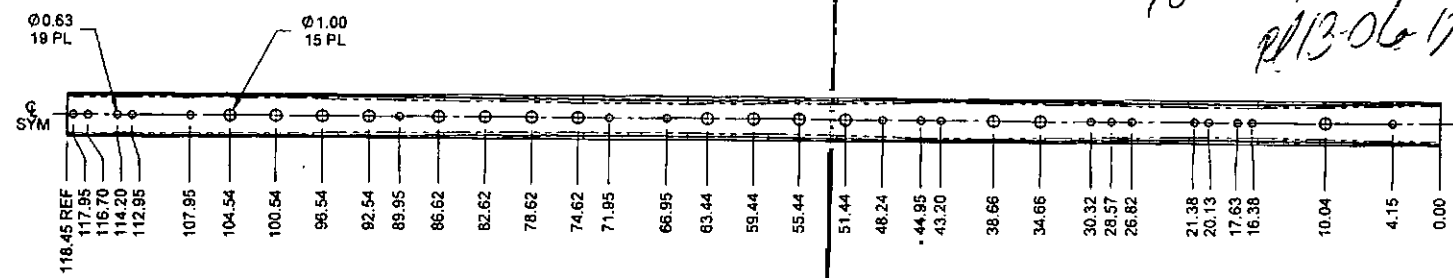
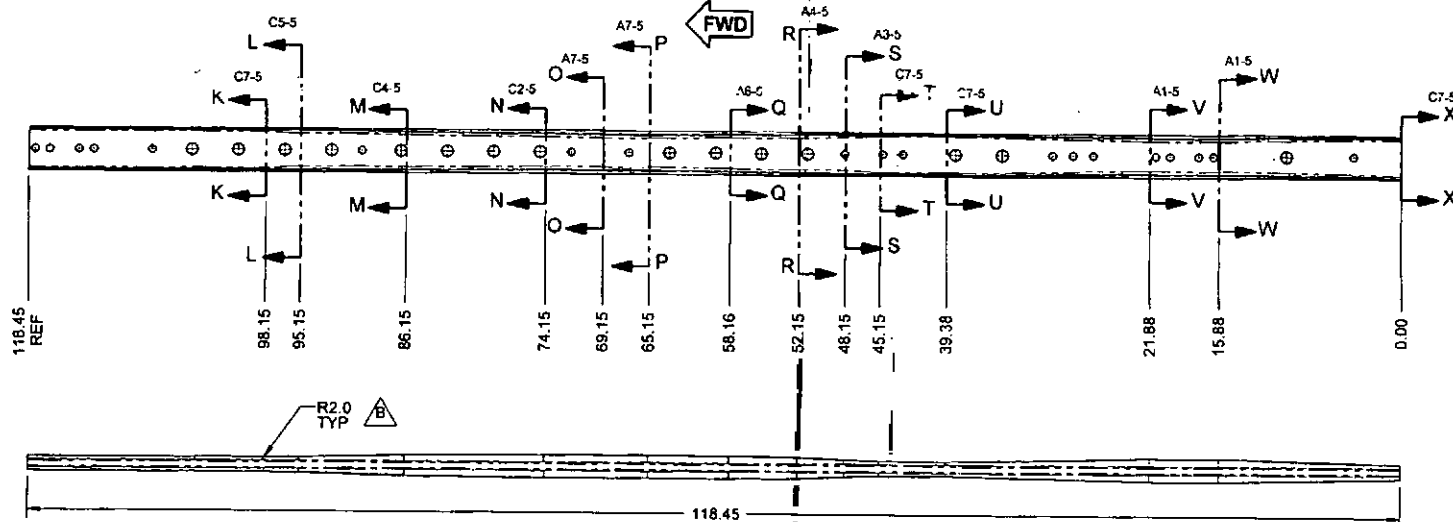
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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D3885-3 FLOAT WEB

D3885-3 NOTES:

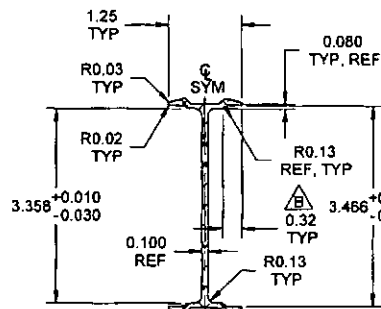
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	<small> COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED TO THE EXTENT OF THE POLICY THAT IT IS NOT TO BE USED AS A BASIS FOR REPRODUCTION OR FOR ANY OTHER PURPOSE WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC. </small>	

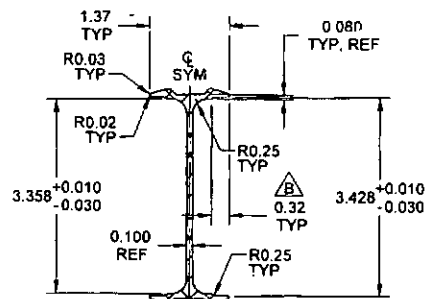
RELEASED
09/07/15/AN

103087
R13-06-17

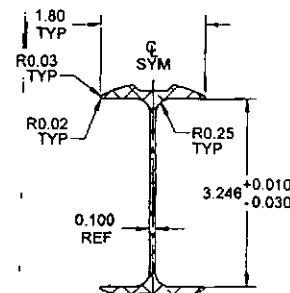
8 7 6 5 4 3 2 1



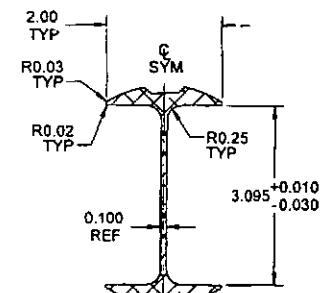
**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X
D7-4
D4-4
D3-4
D1-4



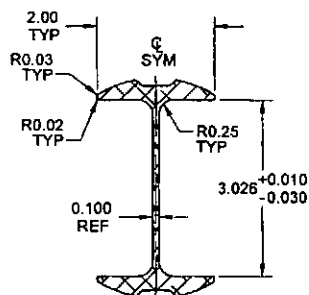
SECTION L-L D6-4
SCALE 5X



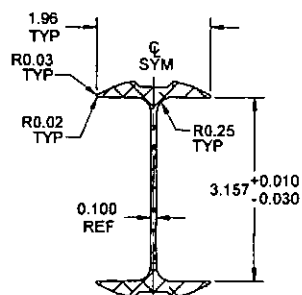
SECTION M-M D6-4
SCALE 5X



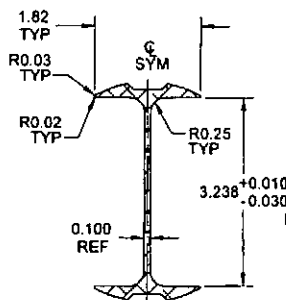
SECTION N-N D5-4
SCALE 5X



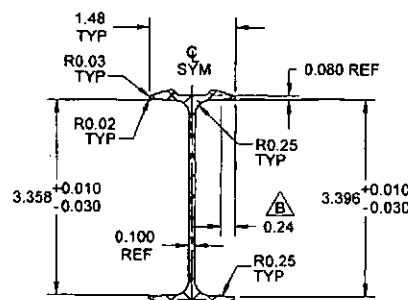
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



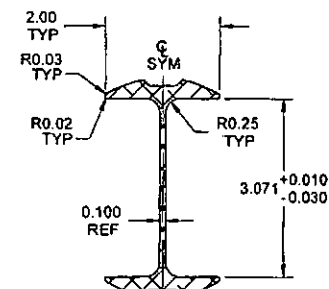
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
D2-4
SCALE 5X

112308

RELEASED
8/17/15

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D3885	REV. B
MFG. APPR.		TITLE WEB	SHEET 5 OF 5
APPROVED		SCALE NTS	
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	
DATE	09.06.30	THIS DOCUMENT IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY REPRODUCTION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO20178

Purchase Order Date 6/14/2013

PO Print Date 6/14/2013

Page Number 1 of 1

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FXED
C. 7/3/2013

Contact Name

Vendor Phone 613-384-1662

Ship To Contact

Ship To Phone

Ship Via: Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

COD

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	List Price	Disc %	Discounted Unit Price	Extended Price
1	D3885-3P MACHINE AS PER DWG D3885 REV. B B103087	Standard Web	7/5/2013 Yes 7/5/2013		8.00 Each				\$4,400.00

Line Total: \$4,400.00

PO Total: \$4,400.00

Note: Pricing listed above is as per contract agreement between Dart Aerospace and the respective manufacturer.

No substitution or deviation without consent.

Certificate of Conformity or Material Certification required ☒ YES ☐ NO

Change Nbr: 2

Change Date: 6/14/2013



Packing Slip 36372

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

SOLD TO Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

SHIP TO Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. PO20178		DATE ORDERED 06/19/13		SHIPPED VIA Best way		
CUSTOMER CODE DART			PROV. LIC. NO.		Extra <input type="checkbox"/> Exempt <input type="checkbox"/>		TERMS	
QUANTITY ORDERED 8	B.O. -	QUANTITY SHIPPED 8	DESCRIPTION Float web as per drawing D3885, Rev.B B3885-3P B103087 Required by: July 7, 2013 NOTE: 1 OF 8 PARTS HAS MACHINING ERROR. PART HAS RED TAG. RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <i>[Signature]</i> WMP 03 July 16, 2013				UNIT PRICE	AMOUNT
							G.S.T.	
							P.S.T.	

ORDER: COMPLETE ☐
PARTIAL ☐

TOTAL

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION

10



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: July. 10, 2013	
		P.O.# PO20178	
		WEJAY JOB# 36372	
<p>I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.</p>			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-3P 'Float Web' Batch# 103087	7	Machined complete per drawing req'ts.	D3885 / rev. B
D3885-3P 'Float Web' Batch# 103087	1	Machined complete - rejected as per NCR# 0139	D3885 / rev. B
<p>Note: 1) Material supplied by Dart Aerospace. 2) Sampling Inspection reports attached.</p>			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,

Clifford Smith
Authorized Q.A. Signatory

WEJAY MACHINE PRODUCTS
Kingston, Ontario

NONCONFORMANCE REPORT

No. 0139

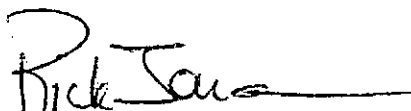
CUSTOMER: Dart Aerospace

P.O. No. PO20178	DWG No. D3885	REV. B	DESCRIPTION: Float Web	QTY. REC. 8	QTY. REL. 1	JOB/BATCH No. 36372	TRACE CODE -	PAGE: 1 of 3
PART No. D3885-3P			RESPONSIBILITY: --	LOCATION: Wejay Insp. -Hold		NONCONF. OP. No. Final machining	LAST COMPLETE OP. No. Part complete	

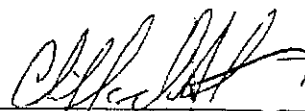
DESCRIPTION OF NONCONFORMANCE		
Item	Qty	
1	1	Cutter damage in web section of part at approx. 99.4" from (drawing) datum end. Elongated sphere-shaped gouge approx. .43" x .50" across x .095" deep (break-through evident on opposite ace of web). See attached photo.

DISPOSITION PROPOSAL	
Item Ref.	
1	Scrap

MFG. SIGNATURE:



INSPECTOR:



DATE: July 8, 2013

DATE: July 8, 2013



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 36372

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PD20178

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.#
--

DATE:

JUNE 28/13

INSTRUCTIONS, COMMENTS:

1st ARTICLE

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	19 places	+ .008/- .001		✓	1	Acc -
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		✓	1	
3	4.15"		+/- .03		✓	1	
4	10.04"		+/- .03		✓	1	
5	16.38"		+/- .03		✓	1	
6	17.63"		+/- .03		✓	1	
7	20.13"		+/- .03		✓	1	
8	21.38"		+/- .03		✓	1	
9	26.82"		+/- .03		✓	1	
10	28.57"		+/- .03		✓	1	
11	30.32"		+/- .03		✓	1	
12	34.66"		+/- .03		✓	1	
13	38.66"		+/- .03		✓	1	
14	43.20"		+/- .03		✓	1	
15	44.95"		+/- .03		✓	1	
16	48.24"		+/- .03		✓	1	
17	51.44"		+/- .03		✓	1	
18	55.44"		+/- .03		✓	1	
19	59.44"		+/- .03		✓	1	
20	63.44"		+/- .03		✓	1	
21	66.95"		+/- .03		✓	1	
22	71.95"		+/- .03		✓	1	
23	74.62"		+/- .03		✓	1	
24	78.62"		+/- .03		✓	1	
25	82.62"		+/- .03		✓	1	
26	86.62"		+/- .03		✓	1	
27	89.95"		+/- .03		✓	1	
28	92.54"		+/- .03		✓	1	
29	96.54"		+/- .03		✓	1	
30	100.54"		+/- .03		✓	1	
31	104.54"		+/- .03		✓	1	
32	107.95"		+/- .03		✓	1	
33	112.95"		+/- .03		✓	1	
34	114.20"		+/- .03		✓	1	
35	116.70"		+/- .03		✓	1	

INSPECTION / TEST REPORT

JOB No.

36372

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. P020178

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
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(1ST ARTICLE)

36	117.95"		+/- .03		✓	1	Acc.
37	1.25" TYP	Section K-K,T-T,U-U,X-X			✓	1	"
38	R.03" TYP				✓	1	"
39	R.02" TYP				✓	1	"
40	3.358"		+ .010/- .030		✓	1	"
41	R.13" TYP				✓	1	"
42	.32" TYP				✓	1	"
43	3.466"		+ .010/- .030		✓	1	"
44	R.13" TYP				✓	1	"
45	.080 TYP, REF				✓	1	"
46	1.37" TYP	Section L-L			✓	1	"
47	R.03" TYP				✓	1	"
48	R.02" TYP				✓	1	"
49	3.358"		+ .010/- .030		✓	1	"
50	R.25" TYP				✓	1	"
51	.32" TYP				✓	1	"
52	R.25" TYP				✓	1	"
53	3.428"		+ .010/- .030		✓	1	"
54	1.80" TYP	Section M-M			✓	1	"
55	R.03" TYP				✓	1	"
56	R.02" TYP				✓	1	"
57	3.246"		+ .010/- .030		✓	1	"
58	R.25" TYP				✓	1	"
59	2.00" TYP	Section N-N			✓	1	"
60	R.03" TYP				✓	1	"
61	R.02" TYP				✓	1	"
62	3.095"		+ .010/- .030		✓	1	"
63	R.25" TYP				✓	1	"
64	2.00" TYP	Section O-O,P-P			✓	1	"
65	R.03" TYP				✓	1	"
66	R.02" TYP				✓	1	"
67	3.026"		+ .010/- .030		✓	1	"
68	R.25" TYP				✓	1	"
69	1.96"	Section Q-Q			✓	1	"
70	R.03" TYP				✓	1	"
71	R.02" TYP				✓	1	"
72	3.157		+ .010/- .030		✓	1	"
73	R.25" TYP				✓	1	"
74	1.82"	Section R-R			✓	1	"
75	R.03" TYP				✓	1	"

INSPECTION / TEST REPORT						JOB No. 36372	
						PAGE: 3 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. P020178							
PART No. D3885-3				DESCRIPTION: Float Web			
DWG No. D3885				REV. B		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
	(1ST ARTICLE)						
76	R.02" TYP				✓	1	Acc.
77	3.238"	Section R-R Cont'd	+.010/-030		✓	1	P
78	R.25" TYP				✓	1	P
79	1.48"	Section S-S			✓	1	P
80	R.03" TYP				✓	1	P
81	R.02" TYP				✓	1	P
82	3.358		+.010/-030		✓	1	P
83	R.25" TYP				✓	1	P
84	3.396"		+.010/-030		✓	1	P
85	R.25" TYP				✓	1	P
86	2.00"	Section V-V, W-W			✓	1	P
87	R.03" TYP				✓	1	P
88	R.02" TYP				✓	1	P
89	3.071"		+.010/-030		✓	1	P
90	R.25" TYP				✓	1	P
91	118.45 2A. LEN				✓	1	P
92							
93							
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600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 36372

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 20178

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: -

N.C.R.# -

DATE:

JUNE 28, 2013

INSTRUCTIONS, COMMENTS:

3RD PIECE OFF

ITEM REF. No.	CHARACTERISTIC (DIMS IN mm)	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	19 places	+ .008/- .001		Acc.	1	Acc.
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		✓	1	"
3	4.15"		+/- .03		✓	1	"
4	10.04"		+/- .03		✓	1	"
5	16.38"		+/- .03		✓	1	"
6	17.63"		+/- .03		✓	1	"
7	20.13"		+/- .03		✓	1	"
8	21.38"		+/- .03		✓	1	"
9	26.82"		+/- .03		✓	1	"
10	28.57"		+/- .03		✓	1	"
11	30.32"		+/- .03		✓	1	"
12	34.66"		+/- .03		✓	1	"
13	38.66"		+/- .03		✓	1	"
14	43.20"		+/- .03		✓	1	"
15	44.95"		+/- .03		✓	1	"
16	48.24"		+/- .03		✓	1	"
17	51.44"		+/- .03		✓	1	"
18	55.44"		+/- .03		✓	1	"
19	59.44"		+/- .03		✓	1	"
20	63.44"		+/- .03		✓	1	"
21	66.95"		+/- .03		✓	1	"
22	71.95"		+/- .03		✓	1	"
23	74.62"		+/- .03		✓	1	"
24	78.62"		+/- .03		✓	1	"
25	82.62"		+/- .03		✓	1	"
26	86.62"		+/- .03		✓	1	"
27	89.95"		+/- .03		✓	1	"
28	92.54"		+/- .03		✓	1	"
29	96.54"		+/- .03		✓	1	"
30	100.54"		+/- .03		✓	1	"
31	104.54"		+/- .03		✓	1	"
32	107.95"		+/- .03		✓	1	"
33	112.95"		+/- .03		✓	1	"
34	114.20"		+/- .03		✓	1	"
35	116.70"		+/- .03		✓	1	"

INSPECTION / TEST REPORT

JOB No. 36372

PAGE: 2 of 3

CUSTOMER: Dart Aerospace

CUST. P.O. PO20178

PART No. D3885-3

DESCRIPTION: Float Web

DWG No. D3885 - sheets 4-5

REV. B

E.C.O. --

REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
----------	----------------	---------	-----------	--------------	--------	------------	---------------------------------

3RD PIECE OFF

36	117.95"		+/- .03		✓	1	Acc.
37	1.25" TYP	Section K-K,T-T,U-U,X-X			✓	1	"
38	R.03" TYP				✓	1	"
39	R.02" TYP				✓	1	"
40	3.358"		+0.010/-0.030		✓	1	"
41	R.13" TYP				✓	1	"
42	.32" TYP				✓	1	"
43	3.466"		+0.010/-0.030		✓	1	"
44	R.13" TYP				✓	1	"
45	.080 TYP, REF				✓	1	"
46	1.37" TYP	Section L-L			✓	1	"
47	R.03" TYP				✓	1	"
48	R.02" TYP				✓	1	"
49	3.358"		+0.010/-0.030		✓	1	"
50	R.25" TYP				✓	1	"
51	.32" TYP				✓	1	"
52	R.25" TYP				✓	1	"
53	3.428"		+0.010/-0.030		✓	1	"
54	1.80" TYP	Section M-M			✓	1	"
55	R.03" TYP				✓	1	"
56	R.02" TYP				✓	1	"
57	3.246"		+0.010/-0.030		✓	1	"
58	R.25" TYP				✓	1	"
59	2.00" TYP	Section N-N			✓	1	"
60	R.03" TYP				✓	1	"
61	R.02" TYP				✓	1	"
62	3.095"		+0.010/-0.030		✓	1	"
63	R.25" TYP				✓	1	"
64	2.00" TYP	Section O-O,P-P			✓	1	"
65	R.03" TYP				✓	1	"
66	R.02" TYP				✓	1	"
67	3.026"		+0.010/-0.030		✓	1	"
68	R.25" TYP				✓	1	"
69	1.96"	Section Q-Q			✓	1	"
70	R.03" TYP				✓	1	"
71	R.02" TYP				✓	1	"
72	3.157		+0.010/-0.030		✓	1	"
73	R.25" TYP				✓	1	"
74	1.82"	Section R-R			✓	1	"

JOB No.	
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PAGE: 3 of 3

E.C.O. ←

